

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012042**Date Inspected:** 15-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Tower				

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

**TOWER ASSEMBLY AREA**

This QA inspector was instructed by task leader to carry out the measurements on the Strut plates for flange to flange, bolt hole distance, stiffener to stiffener distance, 10mm to CJP. The measurements carried out wherever accessible and recorded on the data sheet and submitted to the task leader. The members are identified as Tower Components. The member designations reviewed are as follows.

WD1-A467-18M-2, 3

ND1-A468-18M-2

WD1-1467-23M-1, 2, 3, 4

ND1-A468-23M-2

WD1-A467-28M-1, 2, 3, 4

ND1-A468-28M-2

---

## WELDING INSPECTION REPORT

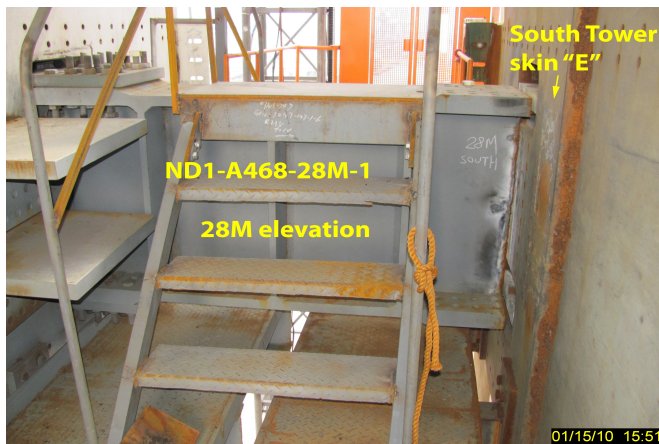
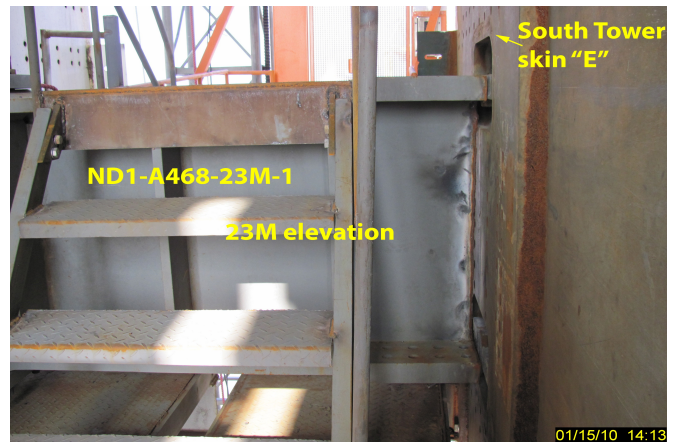
( Continued Page 2 of 3 )

---

During the random Quality Assurance(QA) in process verification of Tower strut, this QA Inspector observed free hand thermal cutting were carried out on edges of the strut plates towards South Tower side. The struts are identified as ND1-A468-23M-1 at elevation level 23M and ND1-A468-28M-1 at elevation level 28M. The thermal cut area is measured approximately 900mm for each strut. The material is designated as Seismic Performance Critical Member (SPCM). The member is located at Tower assembly area (Jetty Area). This issue has an incident report.

The attached photographs provide additional detail.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

**Inspected By:** Gaikwad,Umesh

Quality Assurance Inspector

**Reviewed By:** Clifford,William

QA Reviewer